

Work Order ID 148305***148305***

Page 1

Tuesday, June 28, 2016 9:02:39 AM

Item ID: D205-564-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bell Medium Bearpaws

Stop ***NS2***

Start Date: 6/21/2016 Start Qty: 4.00

4

Required Date: 7/4/2016 Req'd Qty: 4.00

4

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	DAS 6 9-89	JUL 28 2016						
D205-564	H								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork		Photocopy blue file and type labels per PPP D205-564-011 CHG009							

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.02							
Quality Control									

AUG 15 2016

S 27 9-89 PC 28 9-89 AUG 04 2016S 27 9-89

AUG 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Tuesday, June 28, 2016 9:02:38 AM

Page 1

Work Order ID: 148305

148305

Parent Item: D205-564-011

D205-564-011

Parent Item Name: Bell Medium Bearpaws

Start Date: 6/21/2016

Required Date: 7/4/2016

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP F00.01.20 Changed pick list, MPP 2019, CHG006EC
 IPP Rev:G 06-08-28 As per Rev E JLM
 IPP Rev:H 08-01-11 Added Step #2 JLM Verified BY:EC
 IPP Rev:I 08-10-01 New Manufacturing Method JLM Verf By:EC IPP
 REV:J 15.06.05 as per ecn15-574/chg009 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2274 *D2274* Radius Block		Manufactured	No			110	Each	68.0000	20	80-100			DAS 28 9-89

**

PC

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	12	
86855	12	
ST006	56	
110264	12	
144391	44	

100

D2521
D2521
Individual Bearpaw

Manufactured No

110 Each 3.0000

**

2 810
148320x8

DAS
28
9-89

DAS
27
9-89

Location	Loc Qty	Loc Code
ST479a	3	
142767	1	
144894	2	

D2529
D2529
Washer

Manufactured No

110 Each 701.0000

**

2 80-100

PC DAS
28
9-89

DAS
27
9-89

Location	Loc Qty	Loc Code
ST008	701	
108881	12	
145269	189	
147569	500	

72
28

AUG 04 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective: _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Parent Item Name: Bell Medium Bearpaws

148305

D205-564-011

Start Date: 6/21/2016

Required Date: 7/4/2016

Start Qty: 4.00

Required Qty: 4.00

AN4-15A Purchased No 110 Each 202.0000 20

AN4-15A

Bolt

DAS
27
9-89

Location	Loc Qty	Loc Code
GA	26	
120449	26	
over003	150	
m134955	150	
ST343	26	
m134762	26	

**

80 100
55X M134955 P DAS 28 9-89
45X M135127

NAS1149D0463J Purchased No 110 Each 3,549.000 20

NAS1149D0463.J

WASHER

DAS
27
9-89

Location	Loc Qty	Loc Code
GA	86	
M132035	21	
M134508	65	
ST260a	3000	
M134852	1000	
M134943	1000	
M135056	1000	
ST263	463	
M127693	24	
M134754	439	

**

80 100

PC DAS 28 9-89

AUG 04 2016

100

AUG 04 2016

DQA: _____ Date: _____

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Parent Item: D205-564-011

D205-564-011

Parent Item Name: Bell Medium Bearpaws

Start Date: 6/21/2016

Required Date: 7/4/2016

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

110

Each

1,993.000

20

80-100

MS21042L4

Locknut

**

135127 PK DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	161
m133769	161
OVER007	500
m134955	500
ST303	1238
m127376	12
m134861	726
m135058	500
ST305	94
m130922	94

AUG 04 2016

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Shop Packet Print

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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D205-564-011	BEARPAW INSTALLATION
	X		D205-564-013	BEARPAW SKI INSTALLATION
		X	D205-564-015	SKI UPGRADE KIT
20	52	32	D2274	RADIUS BLOCK
2	2		D2521	BEARPAW
20	12	12	D2529	WASHER
4			D3544-041	CLAMP
	2	2	D3795-1	FWD SKI SECTION
	2	2	D3795-3	MID SKI SECTION
	2	2	D3796-041	WEARPLATE
	2	2	D3796-043	WEARPLATE
8	26	18	D4060-1	CLAMP (REPLACES D2947)
8	26	18	D4061-1	CUSHION (REPLACES D2182B055)
	8	8	AN4-12A	BOLT
8			AN4-13A	BOLT
20			AN4-15A	BOLT
	52	52	AN4-20A	BOLT
20	52	32	AN960JD416	WASHERS (OR NAS1149D0463J)
	8	8	AN970-4	WASHER
20	60	40	MS21042L4	NUT (OR MS21042-4)

Qty	Part Number	Description
X	DSI 9328-011	RUN-ON LANDING WEARPLATE KIT
2	D3511-041	WEARPLATE
16	AN4-20A	BOLT
4	AN4-12A	BOLT
4	AN970-4	WASHER
16	MS21042L4	NUT (OR MS21042-4)